Quality Control

Work Ord				*	109	112*						•	Page 1
Item ID: Revision ID: Item Name:	D3903-1 Spacer			Accept	 	*N900	040	100)* s	Setup	Start Stop	*N:	S1*
Start Date: Required Date: Reference:	11/11/13	Start Qty: 80.00 Req'd Qty: 80.00	*80* *80*			Cust Item I Customer:	D:					IW	
Approvals:		Plan: <u>M</u> しゴ	• -				ate:		. F		Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set U Run l	p/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	R	Revision Nbr					_ ·				•		-
D3903	В	3											
100				0.00									
100 Hardinge Hardinge CNC Lath	ne Small	FOLIO REV DWG REV:		0.00 /G D3903,	FK.	(3/11/29.			84	_9	<u> </u>	The second se	
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00									
*11 0 *		Memo		0.00	F.K.	13/11/29			84	Q	*		

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NON	-C(JNFO	RIVIAINCE / U		Vork Order up	odate only	AEROSPACE			
Work Orde	·r·					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS				
Part No				Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstu Machining Small F Thermoforming Finishi Large Fab Compos			_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other					
Root					Desc	ription of work order update	! 	nitial	l Ac	tion	Sign &					
Cause		Date	Step	Qty		or non-conformance	ı	ief Eng	1	ription	Date	Verification	QC Inspector			
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved																
							FA	ULT CA	TEGORY							
Landi		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple nt n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruc Misalia Mislaba Misrea Off-set	ion Incomplete/U tions Incomplete/ gned/off center eled d	Unclear	Outside Dim Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct issing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other			
		Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence	<u> </u>						

November-11-13 1:53:33 PM		*109112*										
Item ID: D3903-1 Revision ID:		Accept	*N90004010									
Item Name: Spacer				Stop *NS2*								
Start Date: 11/11/13 Start Qty Required Date: 11/25/13 Req'd Qt			Cust Item ID: Customer:									
Approvals: Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*								
QC:		SPC (Y/N):	Date:	Stop *NR2*								
Sequence ID/ Operation Work Center ID Description		Set Up/	Tool ID Tool # Plan Code	Accept Reject Reject Insp. Qty Qty Number Stamp								
120 QC8- Inspec	ct parts - second check	0.00		~								
120 QC Quality Control	Memo	0.00	13-11-29	84								
125		0.00		00								
125 Skidtubes		0.00		83 1 13.12.02 PG								
	Memo Clean spacers with Ultra Aluminum Batch:			PTOF								
	per dwg & Stock Location: 1/6	0.00										
120 Packaging Packaging	Memo	0.00										

DQA:		Date:											AADT
QA Closed:		Date:			WORK ORDER NOI	N-C	ONFO	RMANCE / U		Manda Ondana		 -	AEROSPACE
QA Closed.		Date.			<u> </u>				\	Vork Order u	date only		
Work Order	: 109	112			DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
) <u></u>	903	~)		Rework Scrap Use-as-is		Thermoforming Finishi			b Prod. Eng. Coor.			ngineering Quality Other
NCR No). <u> </u>				Suspected Unapproved			Large Fab	Composite		Supplier[
Root Cause	Date	Step	Qty	Desc	ription of work order update or non-conformance		Initial nief Eng		tion ription	Sign & Date	Verification	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	13-12-2	125		1	crosspalt spocer lelldoesen the ain in finnish		DAS 29 9-99	Change C	4	DGL 13-12-02	13-12-2		fut .
-	<u> </u>	1	L			FΔ	IIIT CA	TEGORY					
Landing	Gear				General		OLI CA	i e don'i					
	Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple at n Strip in natter	/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Ui tions Incomplete/U gned/off center eled	` -	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Set- Tem Wel	nperature/Cure d ong Stock Pulled
	Wave/Tw		e		Fit/Function		4	Sequence					

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Work Order	ID	109112
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109112

Page 3

November-11-13 1:53:33 PM Item ID: D3903-1 Accept *N900040100* **Revision ID:** Item Name: Spacer 11/11/13 *80* **Start Qty: 80.00 Start Date: Cust Item ID:** Required Date: 11/25/13 Req'd Qty: 80.00 *80* **Customer:**

Reference:

Approvals:

 Process Plan:
 Date:
 Tooling:
 Date:
 Start
 NR1

 QC:
 Date:
 SPC (Y/N):
 Date:
 NR2

Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Work Center ID Description **Run Hours** Code 140 QC21- Final Inspection - Work Order Release 0.00 *140* QC 0.00 Memo Quality Control

pl(3-12-)

Reject

Insp.

Number Stamp

Setup Start

Reject

Accept

Qty.

DQA:		_ Date:			•			_				DA PT
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE	١٨.	ork Order up	ndate only	AEROSPACE
Work Orde	er:				DISPOSITION			AGAI	NST DI	PARTMENT	/PROCESS	
					Rework			Skid-tube Crosstu	ıbe	7	Water Jet	Engineering
Part N	lo				Scrap			Machining Small	Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming Finish	ing	Rec/Sto	re/Packaging	Other
NCR N	10			_	Suspected Unapproved	Large Fab Composit			site]	Supplier	
Root		Ţ		Desci	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	l	nief Eng			Date	Verification	QC Inspector
Design								, , , , , , , , , , , , , , , , , , , ,				
Doc/Data										:		
Equip/Tooling												
Handling/Pre						İ						
Material								·				
Operator					1							
Offset/Setup												
Process												
Supplier												
Training												
Transport					1							
Unapproved												
						FAI	ULT CAT	regory				
Landir	ng Gear			_	General		_			_		
	Bending				Bend		Folio/P	Program		Outside Dim	ensions	Pressure/Forced
	Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	t [Temperature/Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned V		-
	Heat Trea				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspectio		Tube [,]		Drawing		Misread	i				
	Marks/Cl				Drill Holes		Off-set	•				
		Sequence			Finish		Out of (Calibration				
	Wave/Tw	vist in Tub	e e	1	Fit/Function	1	Out of s	Seguence				

Page 1

November-11-13 1:53:36 PM

Work Order ID: 109112

109112

Parent Item: D3903-1

D3903-1

Parent Item Name:

Spacer

Start Date: 11/11/13

Required Date: 11/25/13

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No		,	100	f	33.8680	0.345	30			
*N 40004TC	TO 075	MALOEON	e						**				

M6061T6T0 375W 058

6061-T6 RD Tube .375 x.058W

Location	Loc Oty	Loc Code
MAT014	33.868	
116920	1.156	
119087	0.11	
123303	8	
123449	16.336	-
124069	8.266	
* 127600		<u> </u>

F.K. 13/11/29.

DQA:			Date: _				_							•	TAART.
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UI	PDATE	W	ork Order up	odate only		AEROSPACE
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS	<u> </u>	
Part N	 No					Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other
NCR N	No					Suspected Unapproved Large Fab			Large Fab	Composite			Supplier	·	
Root	•				Desci	ription of work order update	1	nitial	Act	ion		Sign &			
Cause	Da	ite	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	n	QC Inspector
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Unapproved	L L			i		· · · · · · · · · · · · · · · · · · ·	FΔI	ULT CA	<u> </u> FEGORY						
Landii	ng Gear					General									
	Bend Cent Crac Crim Cuff: Crus Heat Insp	re Not ks p/Kink, s hing t Treat		/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/Un ions Incomplete/U gned/off center eled	•		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	_	_	t in Tub	e		Fit/Function	\vdash	1	Sequence						

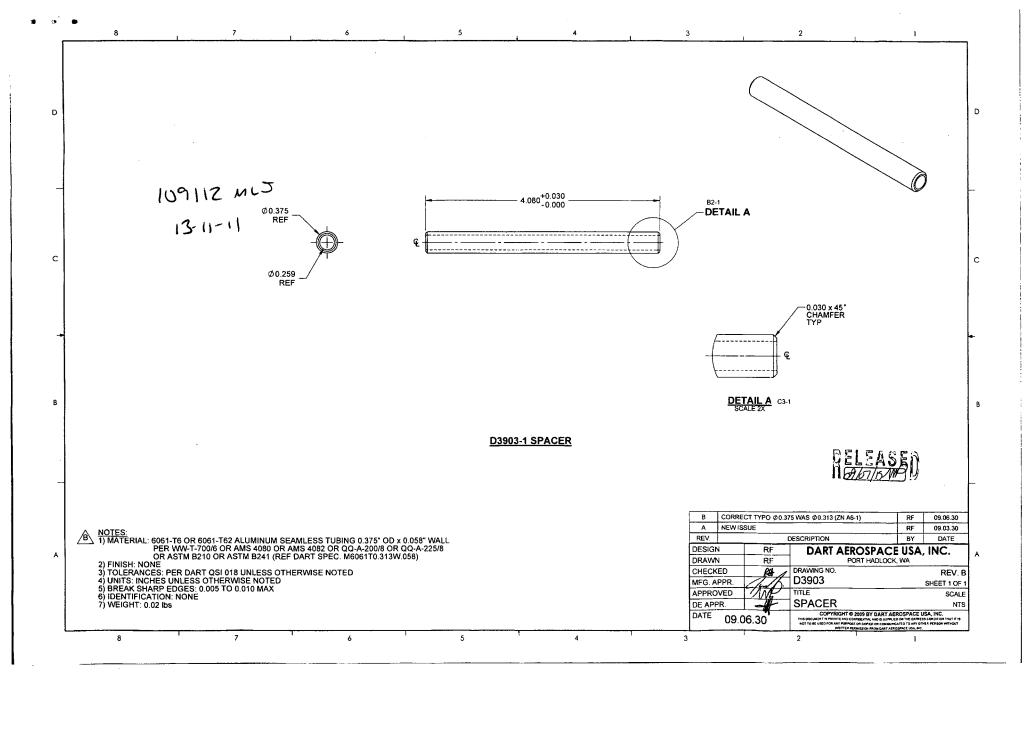
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DART AEROSPACE LTD	Work Order:	109112
Description: Spacer	Part Number:	D3903-1
Inspection Dwg: D3903 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST												
	X	First Article	F	Prototyp	е							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments					
Ø0.375	+0.006/-0.001	<i>ै</i> 375	7		FK-04	Ver	× -					
Ø0.259	+0.006/-0.001	,261	7		4	h						
4.080	+0.030/-0.000	40107	7	·	۸.	4						
0.030 x 45°	+/-0.010 x 0.5°		7		٨	h						
					 							
							 					
												
							3 4 V					
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Measured by:	Ek	Audited by:	7	Pro	totype Approv	al:	N/A					
	Date: 13/11/29 Date: 13-11-2? Date: N/A											
Rev Date	Change		, v. <u>ac</u>		Revised		Approved					

Rev	Date	Change	Revi	se	by !	Approved
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